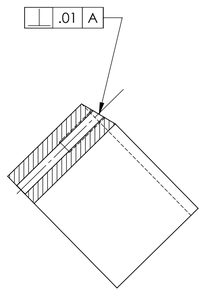
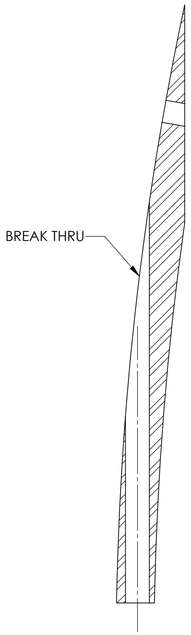
NOTES: UNLESS OTHERWISE SPECIFIED

1. INTERPRET DRAWING PER ASME Y14.5-1994.
2. REMOVE ALL SHARP EDGES 0.005" to 0.015".
3. DO NOT SCALE FROM DRAWING.
4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE. REFER TO LIGO E0900237 FOR LIST OF APPROVED COOLANTS.
5. SCRIBE, ENGRAVE (A VIBRATORY TOOL MAY BE USED), LASER MARK OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX
6. APPROXIMATE WEIGHT = 8.92 LB.
7. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.
8. ALL MATERIAL IS TO BE VIRGIN MATERIAL (i.e. NO WELD REPAIRS, PLUGS OR RECYCLED MATERIAL). NO REPAIRS SHALL BE MADE UNLESS APPROVED IN ADVANCE, AND IN WRITING, BY LIGO LABORATORY. REFER TO LIGO-E0900364.
9. ELECTRO POLISH TO REMOVE .0005-.001 PER SIDE.

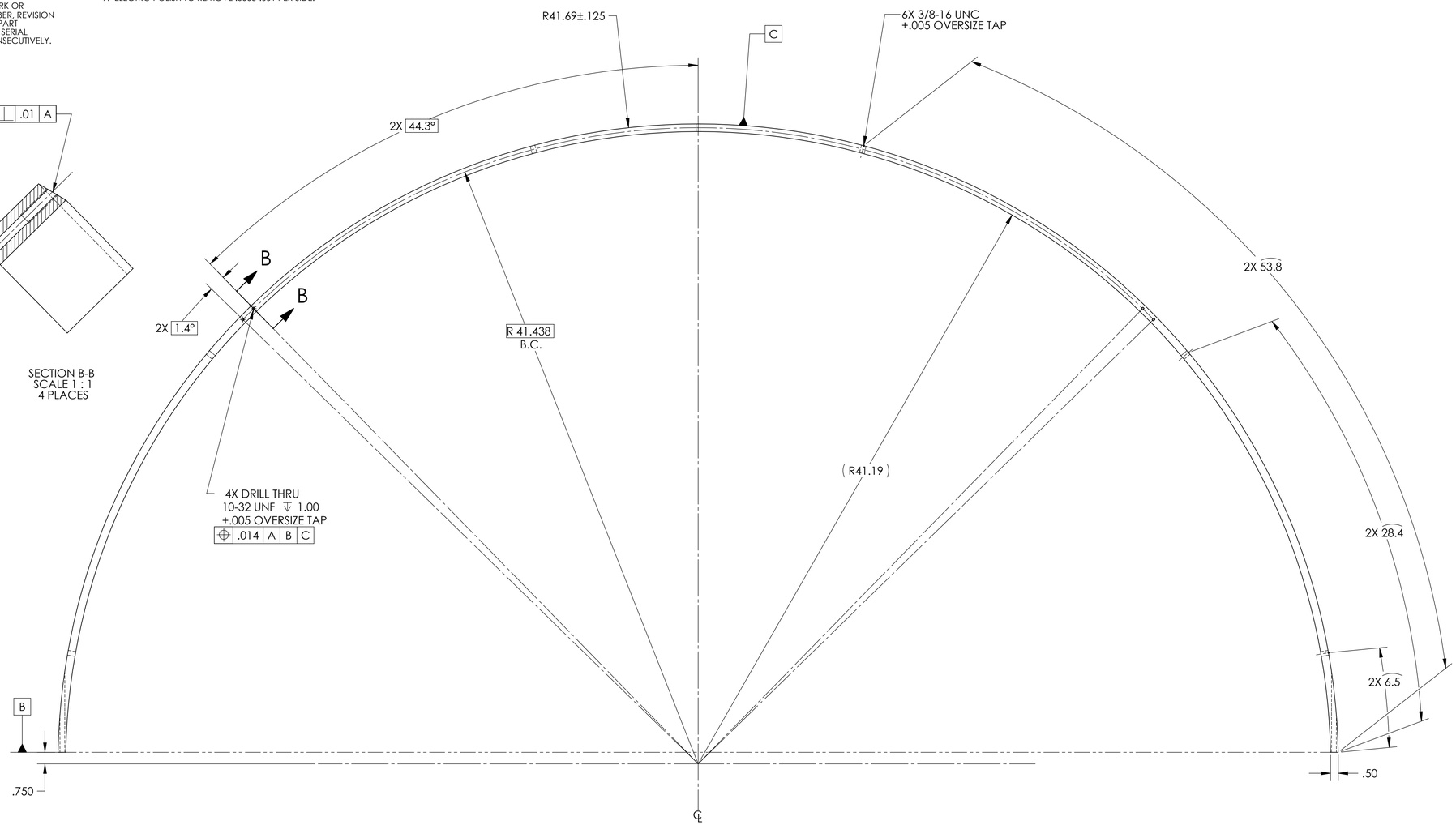
REV.	DATE	DCN #	DRAWING TREE #
v1	19 MAY 2011	E1000822-1	-
v2	18 JUL 2011	-	-
v3	13 FEB 2012	E1000822-v3	-

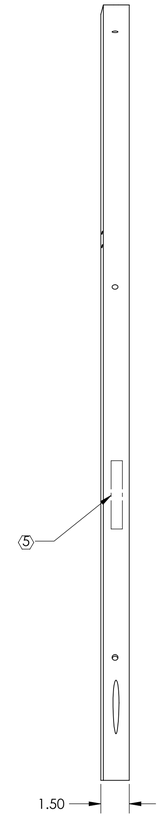


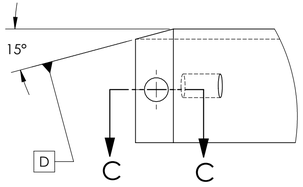
SECTION B-B
SCALE 1 : 1
4 PLACES



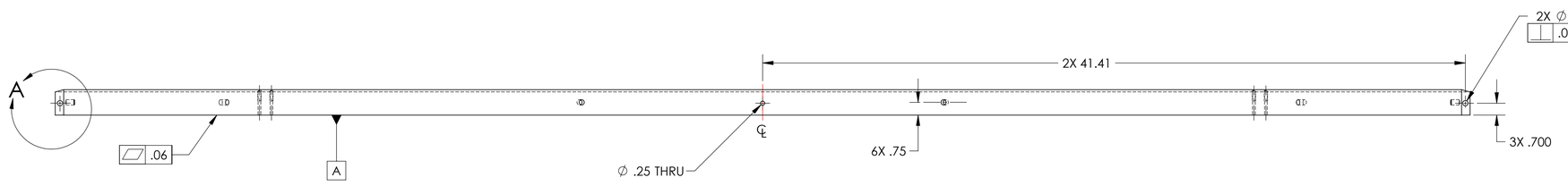
SECTION C-C
SCALE 1 : 1







DETAIL A
SCALE 1 : 1
2 PLACES



NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)									
DIMENSIONS ARE IN INCHES TOLERANCES: X.X ± 1.0 .XX ± .03 .XXX ± .010 ANGULAR ± 0.5°	MATERIAL: 6061-T6 Al	FINISH: 63 µinch	CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY	SYSTEM: ADVANCED LIGO	SUB-SYSTEM: AOS	NEXT ASSY: D1002863	PART NAME: TUBE BAFFLE RING_BOTTOM		
							DESIGNER: H. KELMAN 29 APR 2008	SIZE: D	REV: v3
							DRAFTER: TQ. NGUYEN 8 NOV 2010	DWG. NO.: D1000776	
							CHECKER: M. SMITH		
							APPROVAL: D. COYNE	SCALE: 1:4	SHEET 1 OF 1

D1000776_aLIGO_Mode_Cleaner_Tube_Baffle_Ring_Bottom, PART PDM REV= X.X23, DRAWING PDM REV= X.X28